

Date: Wednesday, 13/05/2009 7:26:17 AM
 User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	1/4 TURN FASTNER RAIL (BLACK)
Job Number :	47928		
Estimate Number :	10096		
P.O. Number :		Part Number :	D103858B
This Issue :	13/05/2009	Drawing Number :	D1038
Prsht Rev. :	NC	Project Number :	N/A
First Issue :	/ /	Drawing Revision :	B
Previous Run :	43343	Material :	
Written By :		Due Date :	28/05/2009
Checked & Approved By :		Qty:	100
Comment :	Um: Each		

S.O. No. :
Type : MACHINED PARTS

Est: E 03.05.02 Reformat; Added label KJ/RF
 Est Rev:F 06-08-16 Updated Packaging Procedures JLM
 Est Rev:G 08-09-16 Added Folio # JLM Verified by:EC

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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for JLD 09/06/08



Comment: DOCUMENT CONTROL
 Create white labels and bag them

2.0	D2023	Extrusion, Fastener Rail
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Comment: Qty.: 1.9030 f(s)/Unit Total : 190.3000 f(s)
 Extrusion, Fastener Rail

3.0	BAND SAW	BAND SAW
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Comment: BAND SAW
 Cut extrusion D2023 to length 21.81" (+0.06/-0.00)

B21907

mmf 09/05/15

4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA783 Rev: *AA* & Dwg D1038 Rev: *B*

2-Deburr per dwg D1038

mmf 09/05/15

5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

mmf 09/05/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D1038-58B PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: P Date: 09/06/08
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>47928</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>09/06/08</u>	<u>12</u>	<u>at the stake</u> <u>1 end crack</u> <u>R.C. process</u>	<u>[Signature]</u> <u>10/06/08</u>	<u>Scrap + destroy</u> <u>no replace</u>	<u>[Signature]</u> <u>09/06/08</u>	<u>SD</u> <u>09/06/08</u>	<u>[Signature]</u> <u>10/06/08</u>	<u>[Signature]</u> <u>10/06/08</u>

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

JL 09/05/17

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Deburr

09/05/20 (100)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09/05/21 (410)

9.0

OUTSIDE SERV.30

OUTSIDE SERVICES-MACH



Comment: Sub-Contracting OUTSIDE SERVICES
Issue P/O: 8836
Black Anodize as per Dwg D1038

09/05/22 (100)

(100) P.O.

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Receive & Inspect For Transit Damage

09/06/01 (100)

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Anodize. Place in foam to protect anodize

09/06/01 (100) counters

12.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
1-Stake .050 stainless steel wire per Dwg D1038-58 using DT8389
Batch: M111948,
2-Grind wire flush and deburr
3-Clean

09/06/08 (99)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #:

Machine Or Operation:

Description :

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Handwritten: 0546-08 QSP019

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

1-Pack each fastener rail into a cardboard tube

2-Roll Part in foam .

3-Install red cap at each end and secure with tape.

4-Apply white labels to cardboard tubes

5-Identify and Stock

Location:

Handwritten: FG14

Handwritten: 9/6/9

Handwritten: 54

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Handwritten: 09/06/09 JA

Job Completion



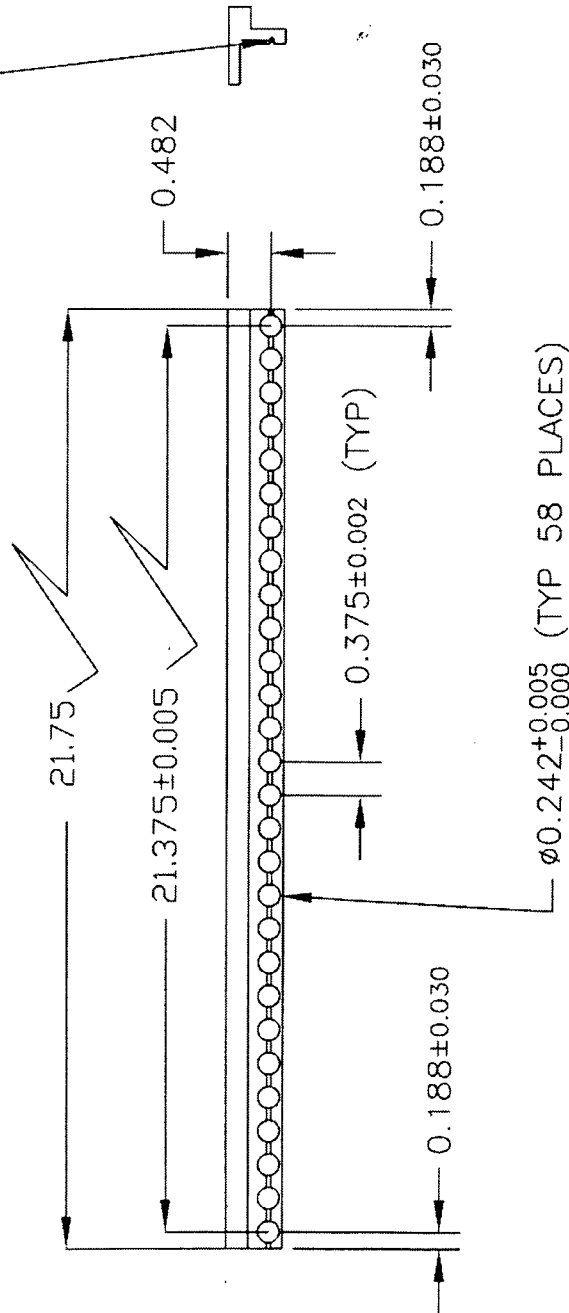
Handwritten: mk 09-06-09



DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D1038	REV. B SHEET 1 OF 1
DATE 05.02.02		TITLE 1/4 TURN FASTENER RAIL	SCALE NTS
	91.05.05	NEW ISSUE	
A	04.05.14	UPDATE TOLERANCE	
B	05.02.02	REDRAWN, UPDATE NOTES	

RELEASED
05.03.01 #

STAKE $\phi 0.50$ TYPE 302 STAINLESS
STEEL WIRE FULL LENGTH
(REF DART SPEC M302SW.050)



47928

D1038-58 1/4 TURN FASTENER RAIL

- 1) MAKE FROM D2023 EXTRUSION
- 2) FINISH: D1038-58 - NONE
D1038-58B - ANODIZE BLACK PER DART QSI 017 4.1.10
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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TNM

ANODISATION et PEINTURE TNM INC.

C. OF C

21 chemin de l'Aviation, Pointe Claire QC H9R 4Z2

Telephone: (514) 429-7777 Fax: (514) 429-5108

Certifié ISO 9001-2000 certified

approuvé NADCAP approved

75432

5/29/2009

CLIENT / CUSTOMER:

DART AEROSPACE LTD.

1270 ABERDEEN STREET

HAWKESBURY, ONTARIO

K3A 1K7

CERTIFICATE OF COMPLIANCE
CERTIFICAT DE CONFORMITENO. DE COMMANDE: 513799
PURCHASE ORDER/

ITEM	COMMANDE ORDERED	QUANTITE SAISIE	PART NUMBER & DESCRIPTION	PART PROCESS & TREATMENT
1	100	100	D1038-58B B47928	MATL: AL BLACK ANODIZE PER MIL-A-8625F TYPE II CLASS 2 ALL OVER

80966101

Nous certifions que les pièces énumérées ont été traitées, testées et inspectées selon les spécifications mentionnées.

Les cartes de travail ont été remplies et sont disponibles pour consultation, sur demande.

All parts are processed, tested, and inspected to the requirements of above specifications.

Travel cards have been filled and are available for viewing upon request.

NOTE: Painted Parts will be Fully Solvent Resistant after 7 (seven) Full Days of Air Curing at Ambient

temperatures"

NOTE: Les pièces peintes seront complètement résistantes au solvant après 7 (sept) jours complets de séchage à l'air

Ambiant.

Signature/Signed: _____

Directeur de la Qualité / Q.A. Manager

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Telephone: (514) 429-7777 Fax: (514) 429-5108

Certifié ISO 9001-2000 certified

Certifié NADCAP certified

**PACKING
SLIP****75432**

5/29/2009

CLIENT / CUSTOMER:**DIRT AEROSPACE LTD.**

1270 ABERDEEN STREET

HAWKESBURY, ONTARIO

K6A 1K7

NO. DE COMMANDE:**PURCHASE ORDER/****513799**

ITEM	QUANTITE ORDERED	DATE ORDERED	DESCRIPTION	QUANTITE IN STOCK
1	100	100	D1038-58B	B47928

PICKED UP BY / RECU: _____

En cas de perte ou de dommages dû à la valeur intrinsèque de certaines responsabilités se limitera à deux fois la valeur du traitement des pièces perdues ou endommagées.

Due to the intrinsic value of some parts, we are only liable for loss or damage to twice the invoiced finishing costs.